

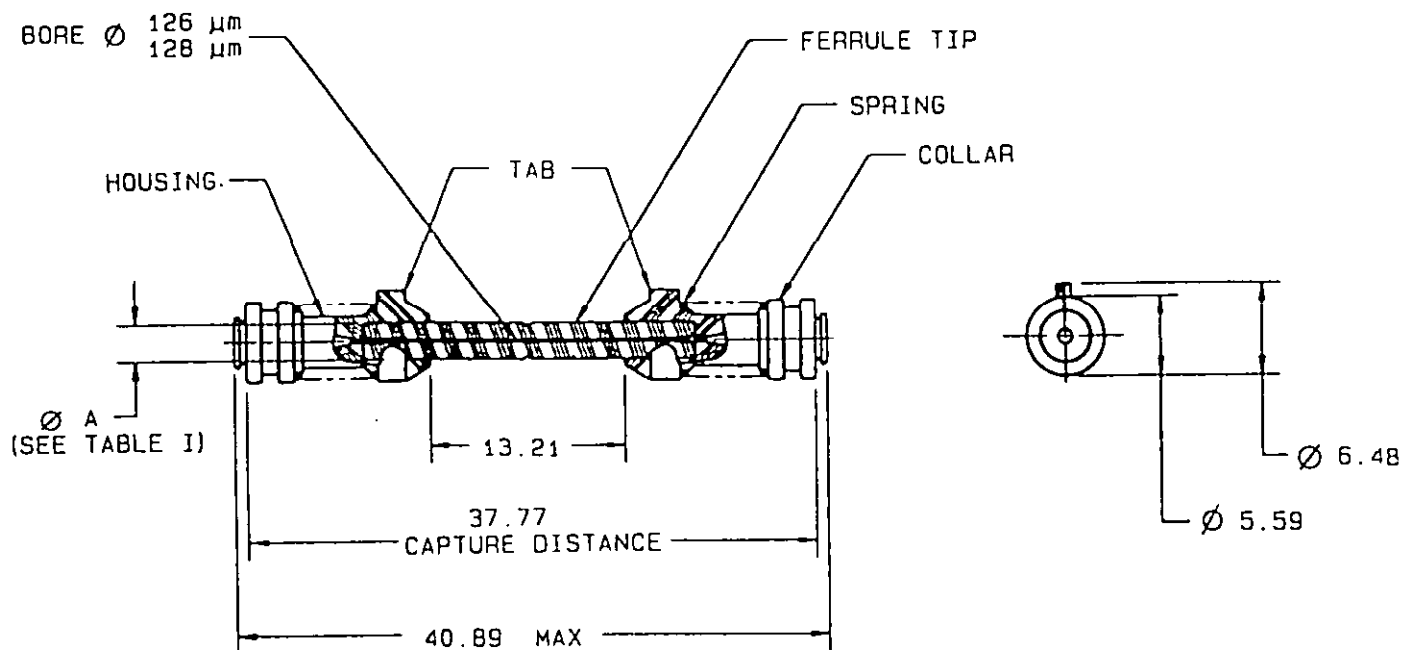
MIL-S-24623/4A
 10 June 1991
 SUPERSEDING
 MIL-S-24623/4 (NAVY)
 26 June 1989

MILITARY SPECIFICATION SHEET

SPLICE, FIBER OPTIC, HOUSING, FIBER

This specification sheet is approved for use by all
 Departments and Agencies of the Department of Defense.

The requirements for acquiring the product described herein shall consist
 of this specification sheet and the issue of the following specification
 listed in that issue of the Department of Defense Index of Specifications
 and Standards (DODISS) specified in the solicitation: DOD-S-24623.



mm	Inches
5.59	.220
6.48	.255
13.21	.520
37.70	1.487
40.89	1.610

NOTES:

1. All dimensions are in millimeters.
2. Inch equivalents are given for general information only.
3. Unless otherwise specified, tolerance is ± 0.10 mm (.004 inch).

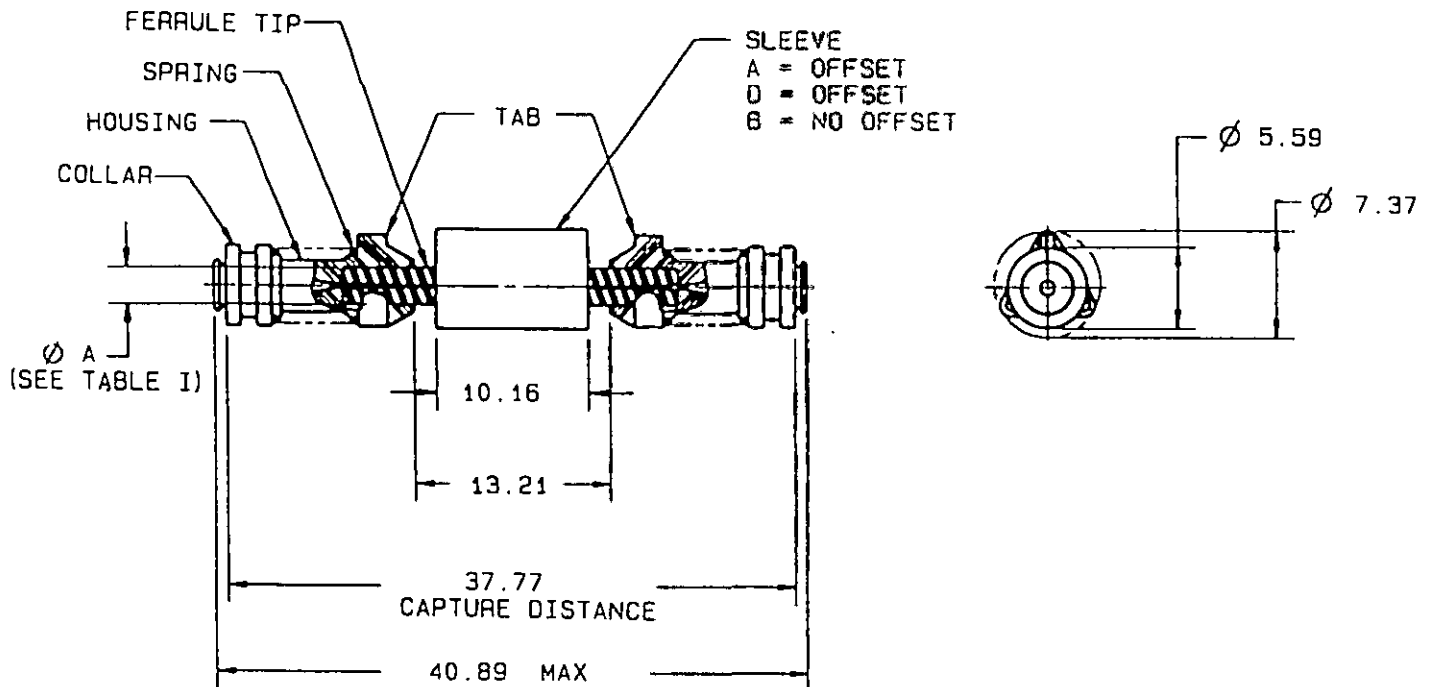
FIGURE 1. Rotary splice.

AMSC N/A

1 of 6

FSC 6060

DISTRIBUTION STATEMENT A. Approved for public release; distribution is unlimited.

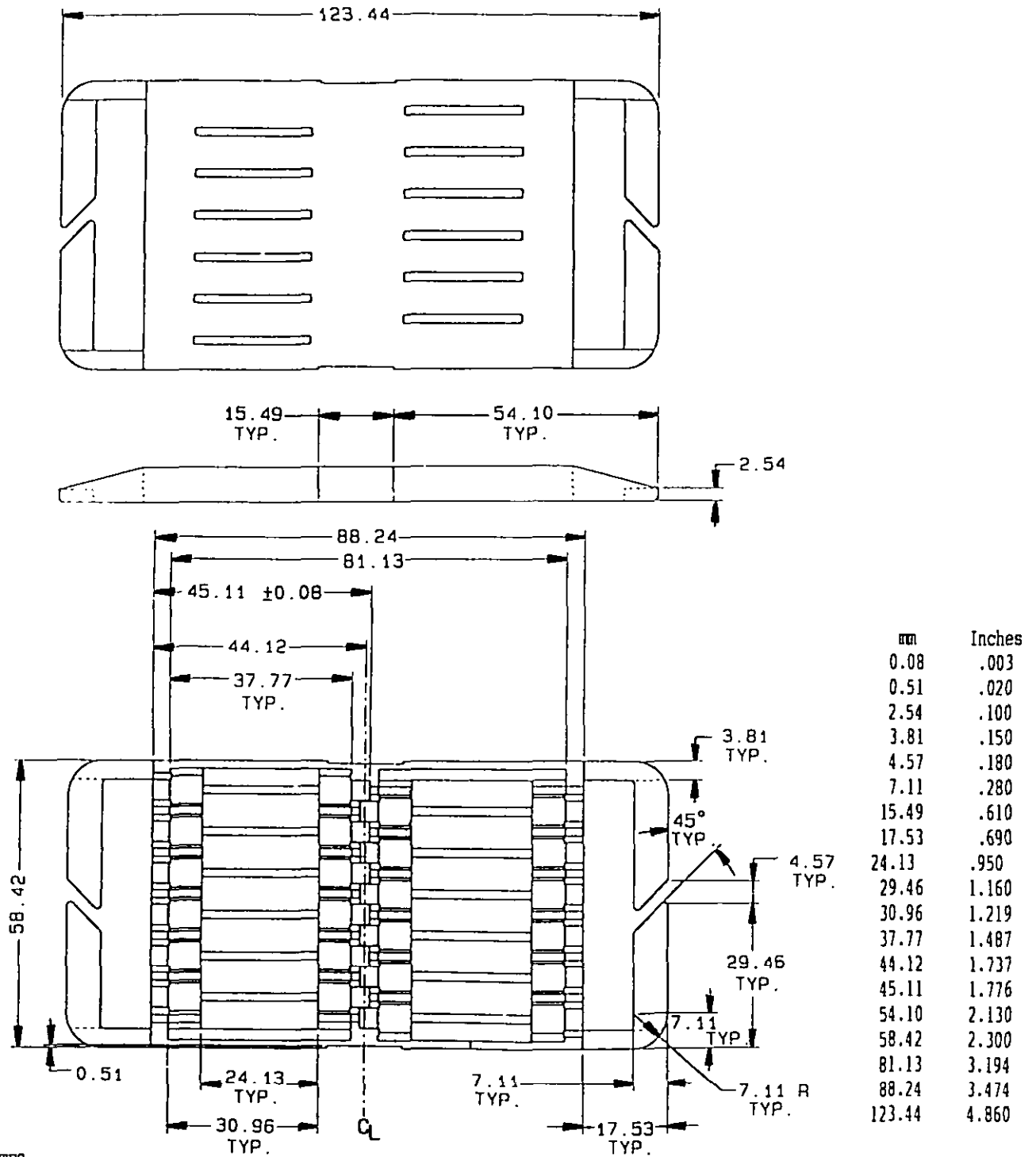


mm	Inches
5.59	.220
7.37	.290
10.16	.400
13.21	.520
37.70	1.487
40.89	1.610

NOTES:

1. All dimensions are in millimeters.
2. Inch equivalents are given for general information only.
3. Unless otherwise specified, tolerance is ± 0.10 mm (.004 inch).

FIGURE 2. Rotary splice with triangular sleeve.



NOTES:

1. All dimensions are in millimeters.
2. Inch equivalents are given for general information only.
3. Unless otherwise specified, tolerance is ± 0.10 mm (.004 inch), angles $\pm 2^\circ$.

FIGURE 3. Rotary splice tray.

TABLE I. Dimension A.

Letter code	Dimension A 1/	
	Min	Max
A	2.4943 (.09820)	2.4956 (.09825)
B	2.4958 (.09826)	2.4968 (.09830)
C	2.4971 (.09831)	2.4981 (.09835)
D	2.4983 (.09836)	2.4994 (.09840)
E	2.4996 (.09841)	2.5006 (.09845)
F	2.5009 (.09846)	2.5019 (.09850)
G	2.5022 (.09851)	2.5032 (.09855)
H	2.5034 (.09856)	2.5044 (.09860)
I	2.5047 (.09861)	2.5057 (.09865)
J	2.5060 (.09866)	2.5070 (.09870)
K	2.5072 (.09871)	2.5083 (.09875)
L	2.5085 (.09876)	2.5095 (.09880)

1/ Dimensions are in millimeters, inch equivalents are in parentheses.

REQUIREMENTS:

Design and construction: See figures 1 and 2.

Fiber style: Single-mode or multimode.

Splice type: Fiber splice.

Weight: Less than or equal to 3 grams.

Ferrule material: Glass, ceramics, or composites.

Exterior parts: Exterior parts of the assembled splice, if metallic, shall have a passivated finish which permits the attainment of a suitable surface finish condition in accordance with high workmanship standards and shall be compatible with external coatings or platings of the type and color specified. The alignment sleeve may be beryllium copper.

Nuclear radiation: N/A.

Freezing water: N/A.

Fluid immersion: N/A.

Sand and dust: N/A.

Crosstalk: N/A.

Salt spray: N/A.

Water pressure: N/A.

Twist: N/A.

Cable seal flexing: N/A.

Axial compression loading: N/A.

Cable pull out: N/A.

Crush: N/A.

Flammability: N/A.

Group A inspection (rotary splice): Test only the ferrule internal diameter dimension.

Tools required: The following AT&T part numbers or equivalent:

842B polishing plate	Pick (spudger)	Microstripper (.006)
992A polishing tool	Heat pad	1011B alignment tool
992B polishing tool	994A alignment clip tool	Water bottle
Eye loupe 7x	6C UV curing lamp	Alcohol bottle
Splice compression tool	UV safety glasses	
Tweezers	975A scoring tool	

Part number:

M24623/04-01* Rotary splice 1/2/
M24623/04-02 Rotary splice tray 3/

Revision letters are not used to denote changes due to the extensiveness of the changes.

1/ The triangular sleeve is an integral part of the rotary splice package.

2/ * is a letter code from table I.

3/ For qualification and quality conformance purposes only, the following tests shall apply: Visual and mechanical inspections, weight, size, thermal shock, operating temperature. For the thermal shock and operating temperature tests, the sample shall be tested using splices in accordance with figure 1.

CONCLUDING MATERIAL

Custodians:

Army - CR
Navy - SH
Air Force - 85

Review activities:

Army - MI
Navy - EC, YD
Air Force - 17, 19, 80, 99
DLA - ES

User activities:

Army - AR
Navy - CG, MC

Preparing activity:

Navy - SH

Agent:

DLA - ES

Project 6060-0090-1j